

**Work Order ID 62425**

September 30, 2010 7:59:35 AM



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Item ID: D4172-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Supporting Plate

Start Date: 9/30/10 Start Qty: 1.00



Cust Item ID:

Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CZ Date: 10/9/30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4172	A
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100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: L

2-Deburr if necessary

0.00

AB 10-9-30

①

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

AB 10-9-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 62425

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Item ID: D4172-1

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Start Date: 9/30/10 Start Qty: 1.00



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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo JM-03 A 1272	0.00  0.00				1			1009-30
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				1	0		
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				1	0		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**Work Order ID 62425**

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Item ID: D4172-1

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Required Date: 10/08/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Identify as per dwg & Stock Location <u>241A</u>	0.00							
Packaging	Memo	0.00							
Packaging									
160 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

10/10/4  
SL  
R

10/10/04  
JG

ME

10-10-021

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

September 30, 2010 7:59:35 AM

Page 1

Work Order ID: 62425



Parent Item: D4172-1



Parent Item Name: Supporting Plate

Start Date: 9/30/10

Required Date: 10/08/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.125

Purchased

No

100

sf

94.2100

1.5645

1.646842



6061-T6 .125 Sheet

1810-9-30

Location

Loc Qty

Loc Code

MAT21

94.21

113608

94

114352

0.21

113608

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DART AEROSPACE LTD		Work Order: 62425
Description: SUPPORTING PLATE		Part Number: D4172-1
Inspection Dwg: D4172-1 Rev: A		Page 1 of 2

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
φ .098	+ .004 - .001	.099	✓		V BO2	
1.500	± .010	1.505	✓		V	
2.912	± .030	2.919	✓		V	
1.53	± .030	1.534	✓		V	
5.70	± .030	5.700	✗		V	
1.73	± .030	1.735	✗		V	
5.00	± .030	4.996	✓		V	
6.00	± .030	5.997	✓		V	
1.000	± .010	1.008	✗		V	
5.431	± .010	5.428	✓		V	
3.54	± .030	3.538	✗		V	
.800	± .010	.802	✗		V	
.350	± .010	.352	✗		V	
.675	± .010	.673	✓		V	
1.435	± .010	1.431	✗		V	
3.000	± .010	3.001	✗		V	
5.375	± .010	5.375	✗		V	
8.550	± .010	8.553	✗		V PRO B62	
22.085	± .010	22.085	✓		T PRO1	
3.155	± .010	3.150	✗		V	
<del>1.438</del>	<del>± .010</del>				V	N/A to be transfer drilled upon Assembly
<del>.719</del>	<del>± .010</del>				V	
<del>1.425</del>	<del>± .010</del>				V	

Measured by: RB
Date: 10-9-30

Audited by: [Signature]
Date: 10-9-30

Prototype Approval: N/A
Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 62425
Description: SUPPORTING PLATE		Part Number: D41721
Inspection Dwg: D4172-1 Rev: A		Page 1 of 1

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# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
41.374	±.010	41.375	✓		T Bal	
38.400	±.010	38.400	✓		T	
31.852	±.010	31.852	✓		T	
28.800	±.010	28.800	✓		T	
2.850	±.010	2.847	✓		U Bal	
<del>1.500</del>	<del>±.010</del>					N/A to be T-Drilled upon Assy
1.500	±.010	1.497	✓		V	
3.352	±.010	3.351	✓			
1.800	±.010	1.800	✓			
<del>1.563</del>	<del>±.010</del>					
<del>2.313</del>	<del>±.010</del>					T-Drill upon Assy
<del>1.156</del>	<del>±.010</del>					
<del>1.560</del>	<del>±.010</del>					
1.624	±.010	1.624	✓		✓	
<del>1.813</del>	<del>±.010</del>					Drill upon Assy
<del>1.806</del>	<del>±.010</del>					
71.400	±.010	71.400	✓			
2.975	±.010	2.972	✓			
75.60	±.010	75.00	✓			
1.125	±.010	1.123	✓			

Measured by: RB	Audited by: [Signature]	Prototype Approval: N/A
Date: 10-9-30	Date: 100930	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

